MULTIMEDIA UNIVERSITY

STUDENT IDENTIFICATION NO

MULTIMEDIA UNIVERSITY

FINAL EXAMINATION

TRIMESTER 1, 2022/2023 (TERM ID 2210)

BOM 2064 – QUALITY AND OPERATIONS MANAGEMENT

(All Sections / Groups)

18 FEBRUARY 2023
9.00 a.m. – 11.00 a.m.
(2 Hours)

INSTRUCTIONS TO STUDENT

1. This question paper consists of **SIX (6) PAGES** with **FOUR (4)** questions only.
2. Answer **ALL** questions. The distribution of the marks for each question is given at the end of each question.
3. Please write all your answers in the answer booklet provided.

QUESTION 1

a) A new machine is set or calibrated to fill tubes of toothpaste at precisely 6.75 ounces. Then, once the machine is running, a sample of **SIX** (6) tubes is taken every three hours and weighed with the following results.

i. Determine all the sample means and the mean of all sample means. (7 marks)

ii. Calculate the upper and lower control limits. (7 marks)

iii. Is the process in control? (1 marks)

		WEIGHT OF TOOTHPASTE					
TIME	7 am	6.69	6.68	6.79	6.77	6.74	6.76
	10 am	6.71	6.72	6.71	6.76	6.75	6.74
	1 pm	6.66	6.68	6.67	6.71	6.76	6.78
	4 pm	6.73	6.74	6.72	6.76	6.78	6.75
	7 pm	6.75	6.73	6.75	6.77	6.79	6.75

Exhibit 1

b) The specification for a plastic liner for concrete highway projects calls for a thickness of 6.0 mm ± 0.1 mm. The standard deviation of the process is estimated to be 0.02 mm. What are the upper and lower specification limits for this product? The process is known to operate at a mean thickness of 6.03 mm. What is the C_p and C_{pk} for this process? About what percent of all units of this liner will meet specifications?

(10 marks)

(Total: 25 marks)

QUESTION 2

a) Differentiate a supply chain from a value chain. (14 marks)

b) As the corporate and operations management strategies vary from low cost to response to differentiation, how does this impact the criteria used for selecting suppliers?

(11 marks)

(Total: 25 marks)

Continued...

QUESTION 3

a) Holstein Computing Sdn. Bhd. manufactures an inexpensive audio card (Audio Max) for assembly into several models of its microcomputers. The annual demand for this part is 100,000 units. The annual inventory carrying cost is RM5 per unit and the cost of preparing an order and making production setup for the order is RM750. The company operates 250 days per year. The machine used to manufacture this part has a production rate of 2000 units per day.

i. Calculate the optimum lot size. (4 marks)

ii. How many lots are produced in a year? (4 marks)

iii. What is the average inventory for Audio Max? (4 marks)

iv. What is the annual holding and setup cost for Audio Max? (4 marks)

b) Average daily demand for a product is normally distributed with a mean of 5 units and a standard deviation of 1 unit. Lead time is fixed at four days.

i. What is the re-order point if there is no safety stock? (3 marks)

ii. What is the re-order point if the service level is 80 percent? (3 marks)

iii. How much more safety stock is required if the service level is raised from 80 percent to 90 percent? (3 marks)

(Total: 25 marks)

QUESTION 4

a) What are the **FOUR** (4) goals of JIT partnerships? (16 marks)

b) A manager wants to determine the number of containers to use for incoming parts for a kanban system to be installed next month.

i. Usage at the work center is 500 parts per day, and a standard container holds 50 parts. It takes an average of 0.24 day for a container to complete a circuit from the time a kanban card is received until the container is returned empty. Compute the number of kanban cards (containers) needed if $X = 0.40$.

(5 marks)

Continued...

ii. Compute the maximum authorized inventory. (2 marks)

iii. Determine the possible inefficiency factor in the system if the average time has reduced to 0.12 day. Assume that all other parameters remain constant. (2 marks)

(Total: 25 marks)

Relevant Equations

1) CL = $\overline{\overline{X}} = \frac{\sum_{i=1}^{k} \overline{x}_i}{k}$, $\overline{R} = \frac{\sum_{i=1}^{k} R_i}{k}$

UCL, LCL (X – bar) = $\overline{\overline{X}} \pm A_2 \overline{R}$

UCL (R) = $D_4 \overline{R}$

LCL (R) = $D_3 \overline{R}$

Table for X – bar & R Charts

No of Observation In sub group n	A2	D3	D4
2	1.88	0	3.27
3	1.02	0	2.57
4	0.73	0	2.28
5	0.58	0	2.11
6	0.48	0	2.00

2) UCL c = $\overline{c} + 3\sqrt{\overline{c}}$

LCL c = $\overline{c} - 3\sqrt{\overline{c}}$

3) $\overline{p}$ = Total No of Defective from All Samples/ (No of Samples X Sample Size)

$Sp = \sqrt{[\overline{p}(1 - \overline{p})/n]}$

CL = $\overline{p}$

LCL = $\overline{p} - 3\,Sp$

UCL = $\overline{p} + 3\,Sp$

4) Capacity Utilization = Capacity Used / Best Operating Level

Continued...

5) $$r = \frac{n\sum XY - [\sum X \sum Y]}{\sqrt{\left[n\sum X^2 - (\sum X)^2\right]\left[n\sum Y^2 - (\sum Y)^2\right]}}$$

$$a = \overline{Y} - b\overline{X}$$

$$b = \frac{n\sum xy - \sum x \sum y}{n\sum x^2 - (\sum x)^2}$$

6) Exponential smoothing

Forecast for the month t: $F_t = F_{t-1} + \alpha(A_{t-1} - F_{t-1})$

7) Inventory Management

$$\text{EOQ} = Q^* = \sqrt{\frac{2DS}{H}} \qquad TC = \frac{Q}{2}H + \frac{D}{Q}S$$

$$\text{EPQ} = Q_0 = \sqrt{\frac{2DS}{H}}\sqrt{\frac{p}{p-u}} \qquad I_{\max} = \frac{Q}{P}(p-u) \qquad TC = \frac{I_{\max}}{2}H + \frac{D}{Q}S$$

$$SS = z\,(\sigma d)\sqrt{LT} \qquad ROP = \bar{d}\,(LT) + z(\sigma d)\sqrt{LT}$$

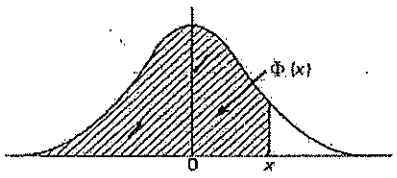
8) Lean Operations

$$N = \frac{DT(1+X)}{C}$$

Continued...

TABLE 4. THE NORMAL DISTRIBUTION FUNCTION

The function tabulated is $\Phi(x) = \frac{1}{\sqrt{2\pi}} \int_{-\infty}^{x} e^{-\frac{1}{2}t^2}\, dt$. $\Phi(x)$ is the probability that a random variable, normally distributed with zero mean and unit variance, will be less than or equal to x. When $x < 0$ use $\Phi(x) = 1 - \Phi(-x)$, as the normal distribution with zero mean and unit variance is symmetric about zero.



x	$\Phi(x)$	x	$\Phi(x)$	x	$\Phi(x)$	x	$\Phi(x)$	x	$\Phi(x)$	x	$\Phi(x)$
0·00	0·5000	0·40	0·6554	0·80	0·7881	1·20	0·8849	1·60	0·9452	2·00	0·97725
·01	·5040	·41	·6591	·81	·7910	·21	·8869	·61	·9463	·01	·97778
·02	·5080	·42	·6628	·82	·7939	·22	·8888	·62	·9474	·02	·97831
·03	·5120	·43	·6664	·83	·7967	·23	·8907	·63	·9484	·03	·97882
·04	·5160	·44	·6700	·84	·7995	·24	·8925	·64	·9495	·04	·97932
0·05	0·5199	0·45	0·6736	0·85	0·8023	1·25	0·8944	1·65	0·9505	2·05	0·97982
·06	·5239	·46	·6772	·86	·8051	·26	·8962	·66	·9515	·06	·98030
·07	·5279	·47	·6808	·87	·8078	·27	·8980	·67	·9525	·07	·98077
·08	·5319	·48	·6844	·88	·8106	·28	·8997	·68	·9535	·08	·98124
·09	·5359	·49	·6879	·89	·8133	·29	·9015	·69	·9545	·09	·98169
0·10	0·5398	0·50	0·6915	0·90	0·8159	1·30	0·9032	1·70	0·9554	2·10	0·98214
·11	·5438	·51	·6950	·91	·8186	·31	·9049	·71	·9564	·11	·98257
·12	·5478	·52	·6985	·92	·8212	·32	·9066	·72	·9573	·12	·98300
·13	·5517	·53	·7019	·93	·8238	·33	·9082	·73	·9582	·13	·98341
·14	·5557	·54	·7054	·94	·8264	·34	·9099	·74	·9591	·14	·98382
0·15	0·5596	0·55	0·7088	0·95	0·8289	1·35	0·9115	1·75	0·9599	2·15	0·98422
·16	·5636	·56	·7123	·96	·8315	·36	·9131	·76	·9608	·16	·98461
·17	·5675	·57	·7157	·97	·8340	·37	·9147	·77	·9616	·17	·98500
·18	·5714	·58	·7190	·98	·8365	·38	·9162	·78	·9625	·18	·98537
·19	·5753	·59	·7224	·99	·8389	·39	·9177	·79	·9633	·19	·98574
0·20	0·5793	0·60	0·7257	1·00	0·8413	1·40	0·9192	1·80	0·9641	2·20	0·98610
·21	·5832	·61	·7291	·01	·8438	·41	·9207	·81	·9649	·21	·98645
·22	·5871	·62	·7324	·02	·8461	·42	·9222	·82	·9656	·22	·98679
·23	·5910	·63	·7357	·03	·8485	·43	·9236	·83	·9664	·23	·98713
·24	·5948	·64	·7389	·04	·8508	·44	·9251	·84	·9671	·24	·98745
0·25	0·5987	0·65	0·7422	1·05	0·8531	1·45	0·9265	1·85	0·9678	2·25	0·98778
·26	·6026	·66	·7454	·06	·8554	·46	·9279	·86	·9686	·26	·98809
·27	·6064	·67	·7486	·07	·8577	·47	·9292	·87	·9693	·27	·98840
·28	·6103	·68	·7517	·08	·8599	·48	·9306	·88	·9699	·28	·98870
·29	·6141	·69	·7549	·09	·8621	·49	·9319	·89	·9706	·29	·98899
0·30	0·6179	0·70	0·7580	1·10	0·8643	1·50	0·9332	1·90	0·9713	2·30	0·98928
·31	·6217	·71	·7611	·11	·8665	·51	·9345	·91	·9719	·31	·98956
·32	·6255	·72	·7642	·12	·8686	·52	·9357	·92	·9726	·32	·98983
·33	·6293	·73	·7673	·13	·8708	·53	·9370	·93	·9732	·33	·99010
·34	·6331	·74	·7704	·14	·8729	·54	·9382	·94	·9738	·34	·99036
0·35	0·6368	0·75	0·7734	1·15	0·8749	1·55	0·9394	1·95	0·9744	2·35	0·99061
·36	·6406	·76	·7764	·16	·8770	·56	·9406	·96	·9750	·36	·99086
·37	·6443	·77	·7794	·17	·8790	·57	·9418	·97	·9756	·37	·99111
·38	·6480	·78	·7823	·18	·8810	·58	·9429	·98	·9761	·38	·99134
·39	·6517	·79	·7852	·19	·8830	·59	·9441	·99	·9767	·39	·99158
0·40	0·6554	0·80	0·7881	1·20	0·8849	1·60	0·9452	2·00	0·9772	2·40	0·99180

Continued...

TABLE 4. THE NORMAL DISTRIBUTION FUNCTION

x	$\Phi(x)$	x	$\Phi(x)$	x	$\Phi(x)$	x	$\Phi(x)$	x	$\Phi(x)$	x	$\Phi(x)$
2·40	0·99180	2·55	0·99461	2·70	0·99653	2·85	0·99781	3·00	0·99865	3·15	0·99918
·41	·99202	·56	·99477	·71	·99664	·86	·99788	·01	·99869	·16	·99921
·42	·99224	·57	·99492	·72	·99674	·87	·99795	·02	·99874	·17	·99924
·43	·99245	·58	·99506	·73	·99683	·88	·99801	·03	·99878	·18	·99926
·44	·99266	·59	·99520	·74	·99693	·89	·99807	·04	·99882	·19	·99929
2·45	0·99286	2·60	0·99534	2·75	0·99702	2·90	0·99813	3·05	0·99886	3·20	0·99931
·46	·99305	·61	·99547	·76	·99711	·91	·99819	·06	·99889	·21	·99934
·47	·99324	·62	·99560	·77	·99720	·92	·99825	·07	·99893	·22	·99936
·48	·99343	·63	·99573	·78	·99728	·93	·99831	·08	·99896	·23	·99938
·49	·99361	·64	·99585	·79	·99736	·94	·99836	·09	·99900	·24	·99940
2·50	0·99379	2·65	0·99598	2·80	0·99744	2·95	0·99841	3·10	0·99903	3·25	0·99942
·51	·99396	·66	·99609	·81	·99752	·96	·99846	·11	·99906	·26	·99944
·52	·99413	·67	·99621	·82	·99760	·97	·99851	·12	·99910	·27	·99946
·53	·99430	·68	·99632	·83	·99767	·98	·99856	·13	·99913	·28	·99948
·54	·99446	·69	·99643	·84	·99774	·99	·99861	·14	·99916	·29	·99950
2·55	0·99461	2·70	0·99653	2·85	0·99781	3·00	0·99865	3·15	0·99918	3·30	0·99952

The critical table below gives on the left the range of values of x for which $\Phi(x)$ takes the value on the right, correct to the last figure given; in critical cases, take the upper of the two values of $\Phi(x)$ indicated.

3·075	0·9990	3·263	0·9994	3·731	0·99990	3·916	0·99995
3·105	0·9991	3·320	0·9995	3·759	0·99991	3·976	0·99996
3·138	0·9992	3·389	0·9996	3·791	0·99992	4·055	0·99997
3·174	0·9993	3·480	0·9997	3·826	0·99993	4·173	0·99998
3·215	0·9994	3·615	0·9998	3·867	0·99994	4·417	0·99999
			0·9999		0·99995		1·00000

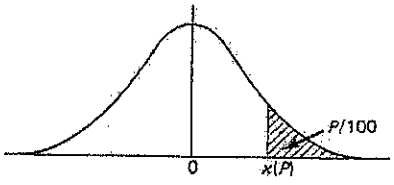
When $x > 3{\cdot}3$ the formula $1-\Phi(x) \doteqdot \frac{e^{-\frac{1}{2}x^2}}{x\sqrt{2\pi}}\left[1-\frac{1}{x^2}+\frac{3}{x^4}-\frac{15}{x^6}+\frac{105}{x^8}\right]$ is very accurate, with relative error less than $945/x^{10}$.

TABLE 5. PERCENTAGE POINTS OF THE NORMAL DISTRIBUTION

This table gives percentage points $x(P)$ defined by the equation

$$\frac{P}{100} = \frac{1}{\sqrt{2\pi}}\int_{x(P)}^{\infty} e^{-\frac{1}{2}t^2}\,dt.$$

If X is a variable, normally distributed with zero mean and unit variance, $P/100$ is the probability that $X \geqslant x(P)$. The lower P per cent points are given by symmetry as $-x(P)$, and the probability that $|X| \geqslant x(P)$ is $2P/100$.



P	$x(P)$	P	$x(P)$	P	$x(P)$	P	$x(P)$	P	$x(P)$	P	$x(P)$
50	0·0000	5·0	1·6449	3·0	1·8808	2·0	2·0537	1·0	2·3263	0·10	3·0902
45	0·1257	4·8	1·6646	2·9	1·8957	1·9	2·0749	0·9	2·3656	0·09	3·1214
40	0·2533	4·6	1·6849	2·8	1·9110	1·8	2·0969	0·8	2·4089	0·08	3·1559
35	0·3853	4·4	1·7060	2·7	1·9268	1·7	2·1201	0·7	2·4573	0·07	3·1947
30	0·5244	4·2	1·7279	2·6	1·9431	1·6	2·1444	0·6	2·5121	0·06	3·2389
25	0·6745	4·0	1·7507	2·5	1·9600	1·5	2·1701	0·5	2·5758	0·05	3·2905
20	0·8416	3·8	1·7744	2·4	1·9774	1·4	2·1973	0·4	2·6521	0·01	3·7190
15	1·0364	3·6	1·7991	2·3	1·9954	1·3	2·2262	0·3	2·7478	0·005	3·8906
10	1·2816	3·4	1·8250	2·2	2·0141	1·2	2·2571	0·2	2·8782	0·001	4·2649
5	1·6449	3·2	1·8522	2·1	2·0335	1·1	2·2904	0·1	3·0902	0·0005	4·4172

End of Page